Work Order February 9, 2010					Ĺ)BEI III/	Midhbi	Page 1
Revision ID:	1016-5		Accept				Setup Sta	
	nge Half, Light Lid /02/2010 Start Qty: 6.0 /02/2010 Req'd Qty: 6.0	1 18 8 de 110 12		Cust Item II Customer:) :		500	P
	rocess Plan:	Date:	Tooling: SPC (Y/N):	Da			Run Sta	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Draw Number		lan Accep ode Qty	t Reject Qty	Reject Insp. Number Stamp
Draw Nbr	Revision Nbr							
D4016	A-PRELIM							
100 Bandsaw	Cut blanks as per fol	io	0.00	L 10/02/04	2	6	&	
Jeaspa Bandsaw		LANK as per folio						
110 HAAS 1	Мето		0.00			_6	Ø	
HAAS CNC vertical made		INE AS PER FOLIO FA874 REV: A	AND DWG	10/02/10				

DEBURR

Packaging

Packaging

Memo



Page 2

February 9, 2010 2:40:15 PM Item ID: D4016-5 Accept Setup Start **Revision ID:** Stop Hinge Half, Light Lid Item Name: Start Qty: 6.00 09/02/2010 **Start Date: Cust Item ID: Required Date:** 12/02/2010 Req'd Qty: 6.00 **Customer:** Reference: Start Run Process Plan: Tooling: Date: Approvals: Date: _____ Stop Date: SPC (Y/N): QC: Date: Sequence ID/ Operation Set Up/ Reject Draw Draw Plan Accept Reject Insp. Rev. Code Qty Qty Stamp Work Center ID **Description Run Hours** Number Number QC2- Inspect parts off machine FAI/FAIB 0.00 120 D.A 10/02/10 Memo Quality Control QC8- Inspect parts - second check 130 Side 11 //04.06 Memo Quality Control Identify as per dwg & Stock Location: 0.00 160 0.00

Work Order ID 56075



Page 3

February 9, 2010 2:40:15 PM

Item ID:

D4016-5

Accept



Setup Start

Stop



Revision ID:

Item Name:

Hinge Half, Light Lid

Start Date:

09/02/2010

QC:

Start Qty: 6.00

Required Date: 12/02/2010 Req'd Qty: 6.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan: _____

Operation

Description

Date: Date:_ Tooling:

SPC (Y/N):

Date:

Date: ____

Run

Start

Stop



Set Up/ **Run Hours**

Number

Draw

Draw Rev.

Plan Accept Otv Code

Reject Reject Qty Number

Insp. Stamp

Sequence ID/ Work Center ID

170

Quality Control

Memo

QC21- Final Inspection - Work Order Release

0.00

0.00

POSITIVE RECALL

EFFECTIVE \ 2020

RELEASED

Picklist Print

February 9, 2010 2:40:14 PM

Work Order ID: 56075

Parent Item: D4016-5

Parent Item Name: Hinge Half, Light Lid

Comments: IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY:DD

Start Date: 09/02/2010

Required Date: 12/02/2010

Page 1

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/	Replacement	Mfg/	Bin Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
Item Name	Item ID	Purch	Item Location	Location	Seq ID	Measure	Hand	Qty To Pick	Issued	Issued	
M6061T6B0.750X00.75		Purchased	No		100	f	21.3411	0.5684			



6061-T6 Bar .750 x .750

Warehouse	Loc Qty	Loc Code

Location

Main Warehouse

MAT 21.34108632

 107387
 2.49

 108877
 3.3453

→ 112567 15.5057863

5684 omf 10/02/09

DART AEROSPACE LTD	Work Order: 56075
Description: HINGE HALF, LID	Part Number: □4016 -5
Inspection Dwg: D4016 Rev: A	Page 1 of 1

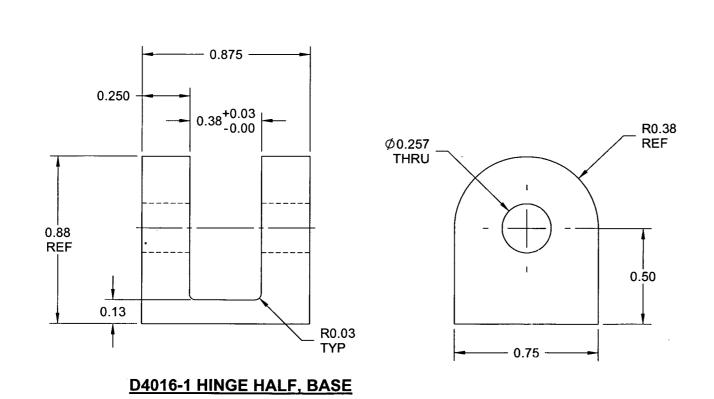
FIRST ARTICLE INSPECTION CHECKLIST

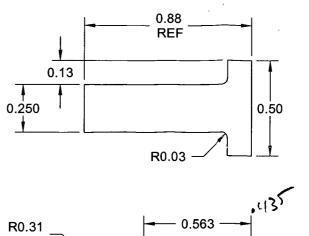
X First Article	Prototype
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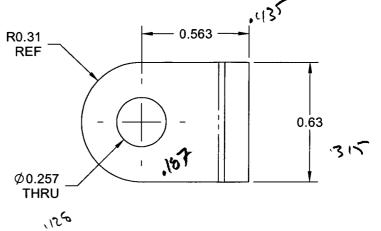
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.88	+/030	0.877	√ * _s			Λ
0.13	+/036	0.125	~			
0.250	+/010	0.251	V			
0.50	+/030	0.501	✓			
RO.03	+/030	RO.032	~			
0.563	+/010	0.562	L			
RO.31	4/030	RO.310	レ		•	•
Ø 0.257	1.006/001	\$0.259	~			
0.63	+/030	0.627	~			
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Measured by:	B.A	Audited by:	Prototype Approval:	N/A
Date:	10/02/10	Date: 10/02/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/JLM	







D4016-3 HINGE HALF, LID D4016-5 HINGE HALF, LID

NOTES: 1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276 PER DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR, PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221

D

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT -1: 0.09 lbs

-3: 0.04 lbs -5: 0.01 lbs

Ten 9th 2010 H.

DESIGN	AJS	DART AEROSPA	CE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4016	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BASKET HINGE	NTS
DATE 09.12	2.04	COPYRIGHT © 2009 BY DART A THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMANICA. NOTTED BY THE PRIVATE OF THE P	ON THE EXPRESS CONDITION THAT IT IS TED TO ANY OTHER PERSON WITHOUT

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